LANL Engineering Standards Manual OST220-03-01-ESM Volume 4, Welding Technique Sheets Attachment 1, Welding Technique Sheet Form

Chapter 13, Welding Rev. 0, 8/16/04

DATE

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WELDING TECHNIQUE SHEET (Sample) Title: WTS No.:							
Drawing No.:				*** 1 0 1			
Referen		Supporting PQR(s):					
		Manual Semi-Automatic Automatic/Machine					
Material: to							
Base Me	etal Thickness:	Deposited Weld Metal Thickness:					
Preparation:				Gas: Fl		Flow l	Rate:
Backing / Back Gouge:					Polarity:		
Welding Position(s):				Stringer or Weave Bead:			
Preheat (Min.) °F:				Inter-pass (Max.) °F:			
Pipe Diameter:				PWHT Required:		☐ Ye	es No
JOINT	SKETCH	SPECIAL INSTRUCTIONS					
Bead or Layer Sequence							
Pass	Filler Metal	Size	Amps	Volts	Travel S	peed	Heat Input (max.)